

ABSTRACT OF THE DISCLOSURE

A broach for internal broaching is formed on its pull end and/or follower end with a tapered surface machined with high accuracy. A pull head and/or a retrieving head of a broaching machine, which drivingly grip the pull end and the follower end the broach, is formed with a tapered inner surface complementary to the tapered surface of the broach. The pull head and the retrieving head grip the broach while pressing and clamping their tapered inner surface against the tapered surface, and these heads and the broach are firmly connected together. Clearances or gaps between the heads and the broach are thus eliminated, concentricity between the heads and the broach is significantly improved, and broaching can be performed with high accuracy.